












Date: Monday, 08/06/2009 1:12:04 PM
 User: Julie Dawson

Process Sheet


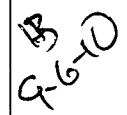
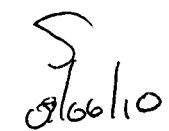
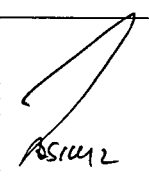
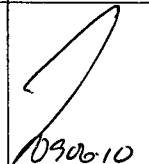
Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 48414	
Estimate Number : 10383	
P.O. Number :	Part Number : D30661
This Issue : 08/06/2009 S.O. No. :	Drawing Number : D3066 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 48103	Material :
Written By :	Due Date : 15/06/2009 Qty: 80 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now M6061-T6 06-06-23 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M6061T6S080
	6061-T6 .080 Sheet
	
	
Comment: Qty.: 0.0992 sf(s)/Unit Total : 7.9380 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) $\times 34 = 3.4$ Batch: <u>110630</u> <u>B 96-10</u> <u>111063x30</u> <u>111003x22</u>	
2.0	WATER JET
	FLOW WATER JET
	
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: <u>B</u> <u>B 96-10</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>B 96-10</u>	
3.0	QC2
	INSPECT PARTS AS THEY COME OFF MACHINE
	
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 96-10</u>	
4.0	QC8
	SECOND CHECK
	
	
Comment: SECOND CHECK <u>Sc 06/10</u> <u>(x86)</u> <u>(86)</u>	
5.0	HAND FINISHING1
	HAND FINISHING RESOURCE #1
	
	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>SR 09-06-11</u> <u>(86)</u>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3066-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 09/06/12

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>48414</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/12	2.0	Part's come out with the holes slightly ovalized. 0.130-70.138. minor blow out RC: Machine malfunction.		<ul style="list-style-type: none"> Program being revised, to ensure the holes will be better. part's acceptable since they are spacers. Ensure to measure per QSP019 				

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 1:12:04 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 48414

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

09-06-11

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Steven

alch

86x

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/12

Job Completion



MF
09-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

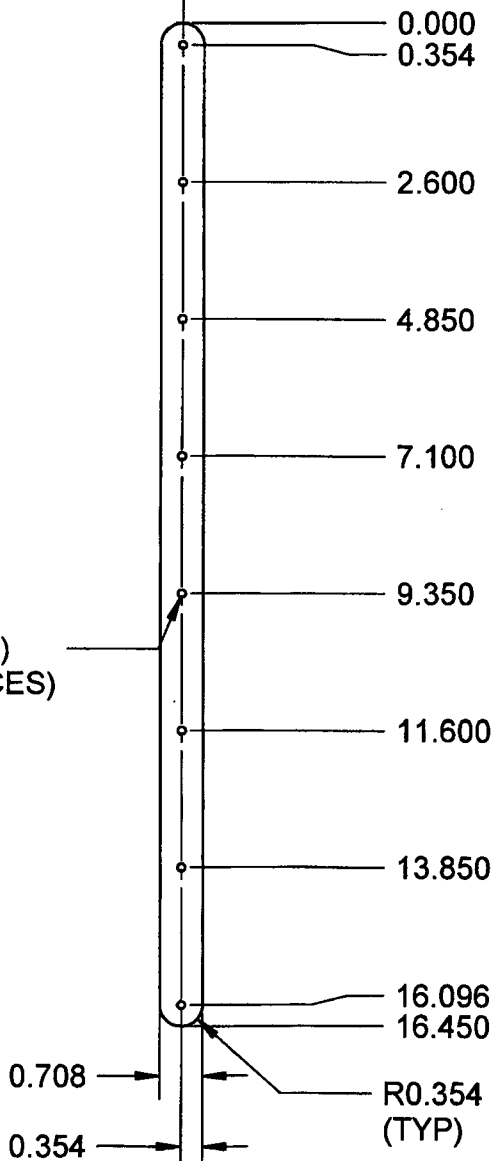
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED*6.6.26*

Ø 0.128 (#30)
(TYP 8 PLACES)

**D3066-1 SPACER**

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *48414*

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.